

76083

Friday, November 04, 2011 3:01:25 PM

N900040100

Setup Start *NS1*

Stop *NS2*

10

10

Reference:

Run Start *NR1*

Date: 4-11-17

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

[illegible]

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 76083***76083***

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Friday, November 04, 2011 3:01:25 PM

Item ID: D2525-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 11/4/2011 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/11/2011 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------|
| 130 *130* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | | | | 10X ✓ M 11/11/10 |
| 140 *140* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | | | | 10 BL 11-11-10 |
| 150 *150* Packaging Packaging | Identify as per dwg & Stock Location <u>16</u> Memo | 0.00 0.00 | | | | | | | 11/10/10 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries


Work Order ID 76083***76083***

Page 3

Friday, November 04, 2011 3:01:25 PM

Item ID: D2525-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 11/4/2011 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/11/2011 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|---|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | 11/11/11 |  |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

UMF
11-11-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Friday, November 04, 2011 3:01:29 PM

Page 1

Work Order ID: 76083

76083

Parent Item: D2525-1

D2525-1

Parent Item Name: Spacer

Start Date: 11/4/2011

Required Date: 11/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B99.11.10Re-format added Acid etch stepEC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6R0.750 | | Purchased | | | No | | | 100 | f | 37.8280 | 0.0625 | 0.657895 | |

M6061T6R0 750

**

6061-T6 Round Bar .750"

Location

Loc Qty

Loc Code

MAT013

37.828

112442

0.796

117481

1.969

118106

1.338

119231

33.725

17

11/11/10

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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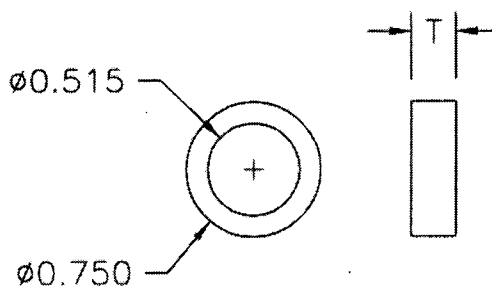
NOTE: Date & initial all entries



| | | | |
|------------------|-------------------------|---|------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED HE | APPROVED [Signature] | DRAWING NO. D2525 | REV. B SHEET 1 OF 1 |
| DATE 99.09.30 | | TITLE SPACER KIT | SCALE 1:1 |
| A | 95.12.22 | NEW ISSUE | |
| B | 99.09.30 | REVISED MATERIAL | |

RELEASED
99.10.12 KE

| PART NUMBER | THICKNESS T | QTY |
|-------------|-------------|-----|
| D2525-1 — | 0.750 | 1 |
| D2525-3 | 0.250 | 1 |
| D2525-5 | 0.125 | 4 |
| D2525-7 | 0.063 | 0 |
| D2525-9 | 0.032 | 0 |
| | | |



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74083

10/11/07

MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

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